

Work Order ID 69783

Thursday, May 19, 2011 9:57:47 AM

Page 1

Item ID: D3654-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 5/19/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: W Date:

Tooling: Date:

Run Start

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3654	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3654 : Dwg Rev: B Prog Rev: B 1.2-
Deburr if necessary

301.063

B11-5-19

(C)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-19

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/11/05/19

(46)

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Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 5/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo 188	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

4/10/19 (6)

4/5/20
MF
11-05-18

Picklist Print

Thursday, May 19, 2011 9:57:44 AM

Page 1

Work Order ID: 69783

Parent Item: D3654-1

Parent Item Name: Doubler





Start Date: 5/19/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-10-29 DD verified by: EC
IPP Rev:B ecn1162 08-04-02 DD verified by:ec
IPP Rev:C 08-09-17 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	194.8000	0.35	1.473684	2		
											B11-5-19		

304/316-Sheet .063

Location

Loc Qty

Loc Code

MAT020

194.8

117275

34.8

117653

160

17275

6

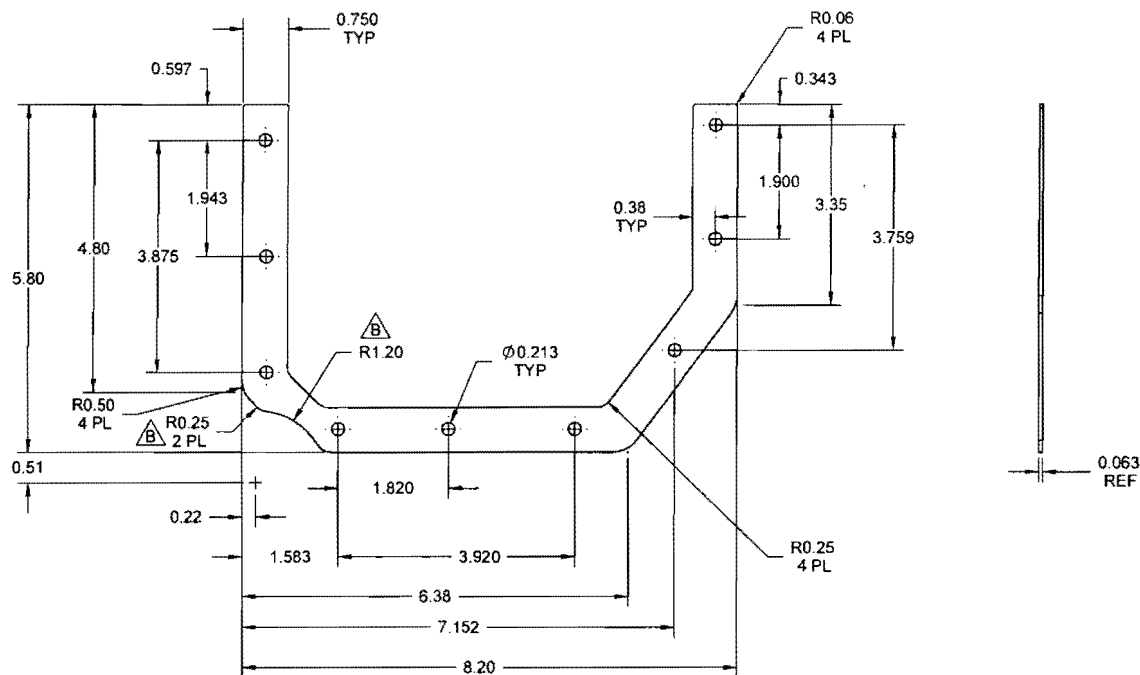
DART AEROSPACE LTD		Work Order: 69783
Description: Doubler		Part Number: D3654-1
Inspection Dwg: D3654	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.213	+0.005/-0.001	.215	✓		V RB02	
0.750	+/-0.010	.751	✓		V	
0.597	+/-0.010	.600	✓		V	
1.943	+/-0.010	1.947	✓		V	
3.875	+/-0.010	3.875	✓		V	
4.80	+/-0.030	4.80	✓		V	
5.80	+/-0.030	5.807	✓		V	
1.583	+/-0.010	1.580	✓		V	
1.820	+/-0.010	1.820	✓		V	
3.920	+/-0.010	3.918	✓		V	
6.38	+/-0.030	6.38	✓		V	
7.152	+/-0.010	7.155	✓		V	
8.20	+/-0.030	8.199	✓		PRO W 302	
0.343	+/-0.010	.345	✓		V	
1.900	+/-0.010	1.903	✓		V	
3.35	+/-0.030	3.35	✓		V	
3.759	+/-0.010	3.757	✓		V	
0.38	+/-0.030	0.377	✓		V	
0.063	+/-0.010	.059	✓		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 11-5-19	Date: 11/5/19	Date:

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	
B	09.12.17	Dimensions updated per Dwg Rev B	KJ	
C	11.01.17	Dwg Rev updated to B	KJ	



D3654-1 DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.063 (16 GAUGE) SHEET PER AMS 5513/5524 (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3654-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

RELEASED
18-07-16

B	ADD R1.20 & R0.25 (ZIN C6); MATERIAL NOTE AMS 5513/5524 WAS MIL-S-5018 (ZIN A6); REFORMATTED DRAWING TO CURRENT STANDARD	RF	08.09.11
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.11		
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